



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D3009-3

Job Sheet 186371



Part No: D3009-3

Job Qty: 30 ea

Part Name: Cup



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/14/18

Job Tracking No:

Due Date: 11/30/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP A 07.12.18 new issue EC IPP Rev:B 08-01-08 ECN 1089 rev:b as per dwg DD verified by:ec

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	30 Ea	11/30/18	11/30/18	0.00	0.00	Start Up Machining-1		V/S SBD 18/11/19
100	Hardinge	30 pcs	11/30/18	11/30/18	0.00	3.55	Hardinge		11/18/19
120	QC	30 pcs	11/30/18	11/30/18	0.00	0.00	QC8		11/18/19
130	Packaging	30 pcs	11/30/18	11/30/18	0.00	0.00	Packaging3-1		11/18/19
140	QC21-SA	30 Ea	11/30/18	11/30/18	0.00	0.00	QC21		11/18/19

Part Op 100 - 1-TURN AS PER FOLIO FA130 & DWG D3009
Descriptions: 130 - *****STOCK IN LARGE FAB***** LOCATION WA002

DAS
21
9-88

NOV 20 2019

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304R1.000	304 Round Bar 1.00	1.4370 ft (.0479 ea)	90-Start up Operation	5128860

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304R1.000	1	4	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Cup	0.875Inches + 0.000 - 0.005	0.875 0.870	Diameter	
2	Cup	0.750Inches + 0.008 - 0.001	0.758 0.749	Diameter	
3	Cup	0.266Inches + 0.006 - 0.001	0.272 0.265	Diameter	
4	Cup	0.062Inches ± 0.010	0.072 0.052	Radius	
5	Cup	0.094Inches ± 0.010	0.104 0.084		
6	Cup	0.353Inches ± 0.010	0.363 0.343		
7	Cup	0.063Inches ± 0.010	0.073 0.053		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			Completed By
					Lead hand / Supervisor Approval Verification
					QC / QA Coordinator Approval
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

8	Cup	0.032Inches ± 0.010	0.042 0.022	Radius
9	Cup	45.000Degrees ± 0.000	45.000 45.000	Angle

Plex 11/14/18 3:07 PM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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